

# Work Order ID 53016

October 21, 2009 10:40:02 AM



Page 1

Item ID: D119-696-043

Accept



Setup Start



Revision ID: A2

Stop



Item Name: Dual Cargo Mirror Assy

Start Date: 21/10/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 29/10/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *RP*

Date: *09-10-21*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3074

Rev A2

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- punch one side 2- slide parts in tube 3- punch other side 4- bend as per  
dwg D3074 5- drill holes as per dwg D3074 6- deburr and polish

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

120

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D3074

*P10* →

*4X*

*M-L 09/10/26*  
*M-L 09/10/28*

*4X*

*⇒ 8 09/10/30*

*4X*

*⇒ M-L 09/11/02*

*4X*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Do not duplicate:  
See NCR 09-102

Part No: D119-696-043 PAR #: N/A Fault Category: ENG. Dwg NCR: Yes ☒ No ☐ DQA: H Date: 09.11.06  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>53016</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/10/26	#100	wrong wall thickness used when making mirror arm. employee used 0.035" wall should have used 0.049" wall.		-Scrap and Destroy and replace with correct #304 T.R.O. 500" wall 0.049" M# 111814 (4X)	M-H 09/10/27	S 09/10/30		S 09/10/06
		Rt. employee saw 0.035" wall on w/o and in Dwg. did not understand the change. R.C. Eng - drawing.		-Fix w/o to read correct change to of mat - See NCR 09-102.	 09/11/03	↓		S 09/10/06

NOTE: Date & initial all entries

**Work Order ID 53016**

October 21, 2009 10:40:02 AM



Page 2

Item ID: D119-696-043

Accept



Setup Start



Revision ID: A2

Stop



Item Name: Dual Cargo Mirror Assy

Start Date: 21/10/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 29/10/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00	2) 802/11/02			(26)	/		
140  Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo	0.00 0.00				9/11/02	(46)		
150  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00				09/11/03			

MF

09-10-02

# Picklist Print

October 21, 2009 10:40:06 AM

Page 1

Work Order ID: 53016

Parent Item: D119-696-043RevA2

Parent Item Name: Dual Cargo Mirror Assy

Comments:

Start Date: 21/10/2009

Required Date: 29/10/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10		Purchased	No				Each	1,906.000	24.0000			

Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1906	
105442	95	
109059	2	
109840	23	
110985	202	
111279	5	
111668	64	
112314	1000	
112369 ✓	515	

M-1 09/10/26

M112369 (24x)

D2011-101RevG

Manufactured No



6" Mirror

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	48	
22179	0	
43793	11	
47592	1	
51351 ✓	36	

M-1 09/10/26

B51351 (8x)

# Picklist Print

October 21, 2009 10:40:06 AM

Work Order ID: 53016

Parent Item: D119-696-043RevA2

Parent Item Name: Dual Cargo Mirror Assy

Start Date: 21/10/2009

Required Date: 29/10/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2054RevB

Manufactured

No

Each

24.0000

8.0000



Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

24

39433 ✓

24

Each

35.0000

8.0000

D2055RevC1

Manufactured

No



Clamp

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

35

34365 ✓

5

47562 ✓

30

Each

20.0000

4.0000

D2056RevB2

Manufactured

No



Bell Crank

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

20

51429 ✓

20

M-L 09/10/26

B39433 (8X)

M-L 09/10/26

B34365 (4X)  
B34562 (4X)

M-L 09/10/26

51429 (4X)



# Picklist Print

Page 4

October 21, 2009 10:40:06 AM

Work Order ID: 53016

Parent Item: D119-696-043RevA2

Parent Item Name: Dual Cargo Mirror Assy

Start Date: 21/10/2009

Required Date: 29/10/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bju Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L3		Purchased	No				Each	3,471.000	12.0000			
Nut												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	3471	
110844	32	
111274	35	
111668 ✓	904	
112314	2000	
112385	500	

M-L 09/10/26

M111668

MS27039-1-18

Purchased

No

Each

84.0000

12.0000



Screw

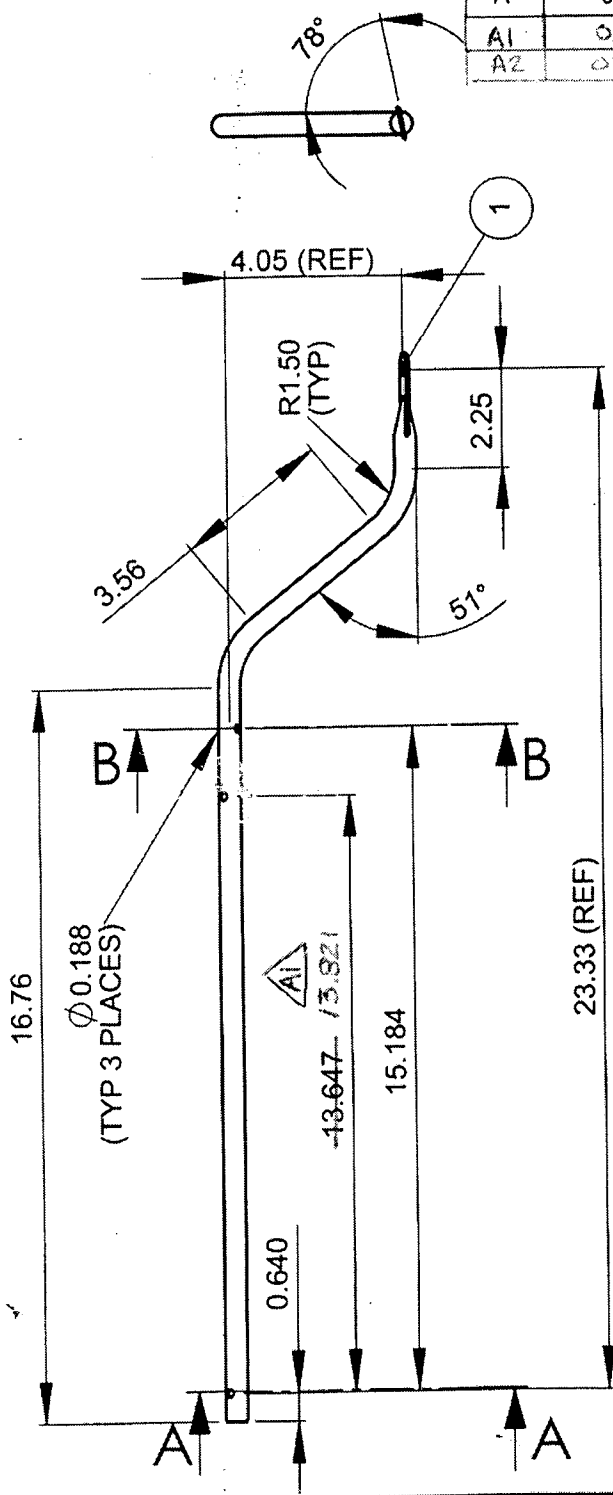
<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	84	
110916 ✓	84	

M-L 09/10/26

M110916



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D3074 REV. A SHEET 1 OF 2
DATE	01.12.17	TITLE	ARM	SCALE 1:4
A	01.12.17	NEW ISSUE		
A1	02.01.15	13.821 WAS 13.647	CP	
A2	02.03.22	ADD FINISH	CP	



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WORK ORDER  
NO. 53016

B109-10-21

UNDER REVIEW

03.06.23  
CHANGE TO 0.049"  
WALL TUBING

SECTION B-B  
(1 PLACE)

SECTION A-A  
(TYP 2 PLACES)

RELEASED  
02.01.15

D3074-1

- 1) PUNCH END PER SPEC CONTROL DRAWING D2727
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE,  $\phi 0.50 \times 0.085$  WALL  
ENSURE SEAMLESS TUBING IS USED
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) FINISH: POWDER COAT BLACK SHINTEX (435-7) PER DART QSI 005 4.3 A2

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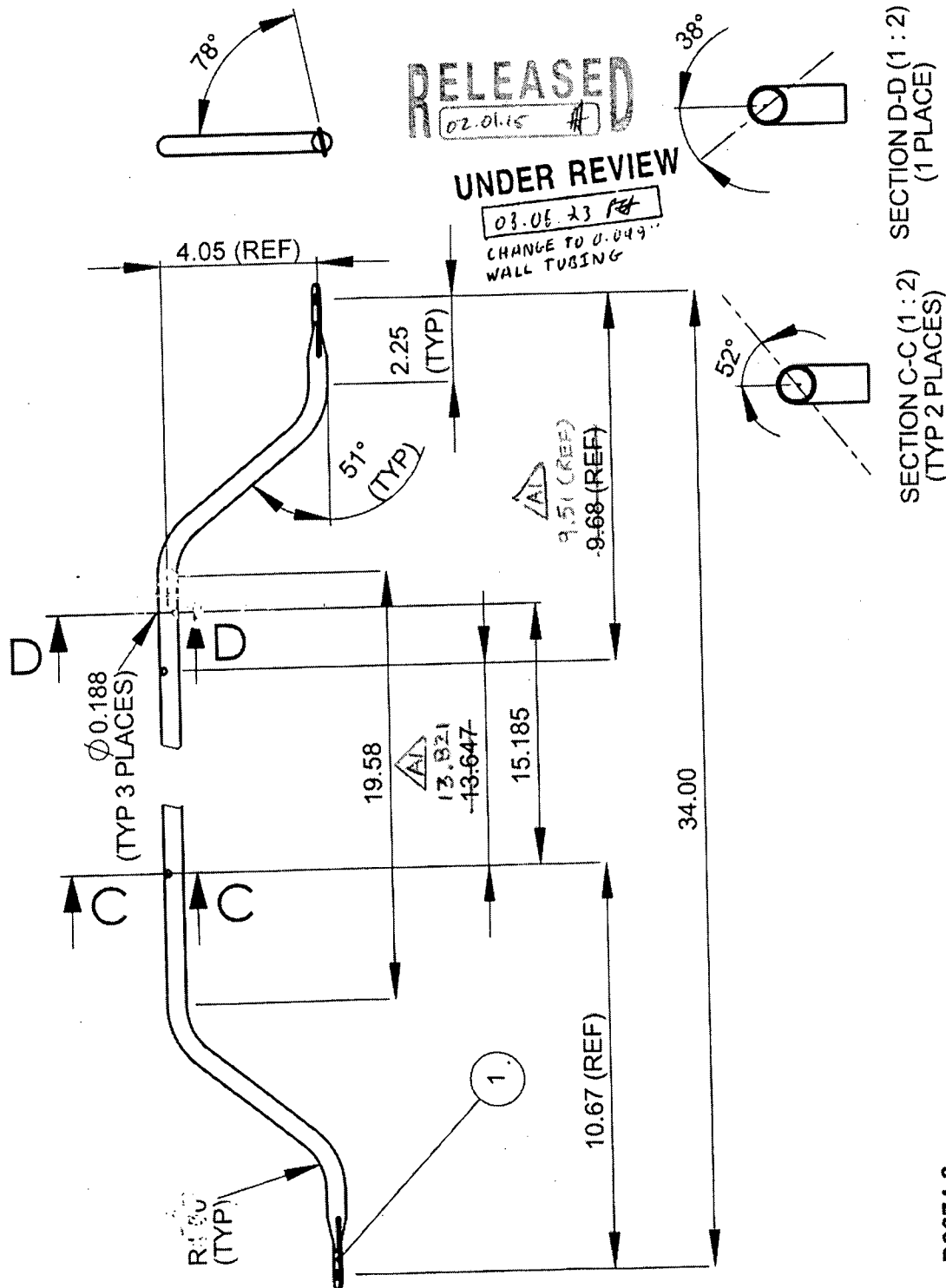
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WORK ORDER  
NO. 58016



DESIGN UP	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3074	REV. A SHEET 2 OF 2
DATE 01.12.17	TITLE ARM		SCALE 1:4



D3074-3

- 1) PUNCH ENDS PER SPEC CONTROL DRAWING D2727
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE,  $\phi 0.50 \times 0.035$  WALL  
ENSURE SEAMLESS TUBING IS USED
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS NOT SYMMETRIC

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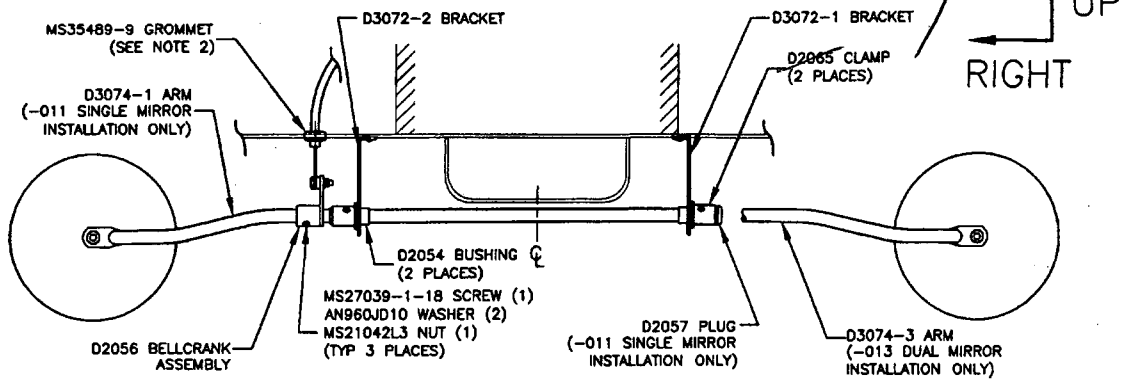
D2055 CP  
05.10.22

Figure 2 - View A: Looking Aft  
(D119-696-011/-013 Mirror Shown)

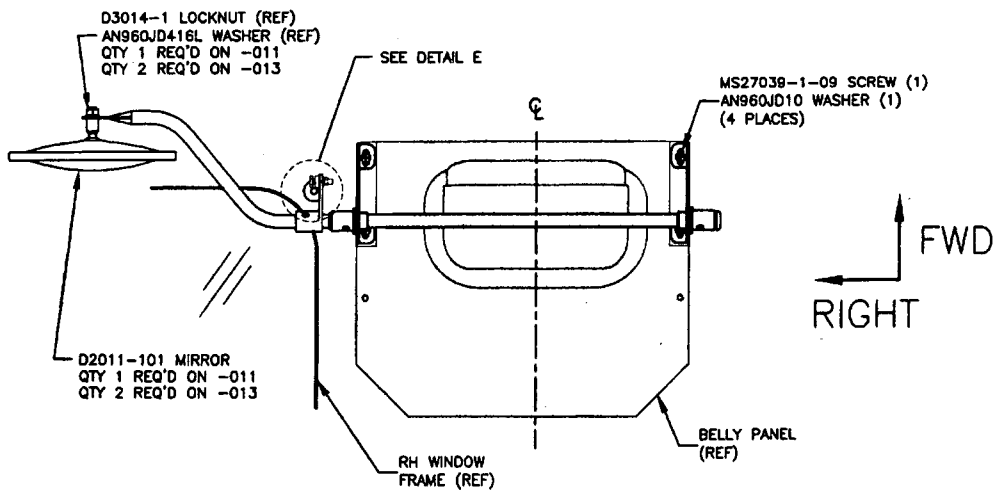


Figure 3 - View B: Looking Up  
(D119-696-011 Mirror Shown, -013 similar)

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Revision: A

Date: 01.12.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries